

Work Order ID 149958

August 16, 2016 9:40:14 AM

149958

Ship Aug 30

Page 1

Item ID: DSI 9410-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Amends Installation of D350-591-311/-312 Steps

Stop

NS2

Start Date: 8/16/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 8/30/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

SU

Date: AUG 15 2016

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr		DAS						
DSI 9410	B		6						
			9-89						

100

Document Control

AUG 17 2016

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP DSI 9410-011
CHG002

DAS
21
9-89

AUG 19 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
28
9-89

AUG 17 2016

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.03

Quality Control

DAS
6
9-89

AUG 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 149958

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Page 2

Item ID: DSI 9410-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Amends Installation of D350-591-311/-312 Steps

Start Date: 8/16/2016 Start Qty: 5.00 ***5***

Cust Item ID:

Required Date: 8/30/2016 Req'd Qty: 5.00 ***5***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI 9410-011								
	Location: <u>FG123</u>								
	PPP rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.08							
Quality Control									

DAS 28 9-89 **AUG 19 2016**

DAS 21 9-89 **AUG 19 2016**

AUG 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : ☐											

Picklist Print

August 16, 2016 9:40:19 AM

Page 1

Work Order ID: 149958

149958

Parent Item: DSI 9410-011

DSI 9410-011

Parent Item Name: Amends Installation of D350-591-311/-312 Steps

Start Date: 8/16/2016

Required Date: 8/30/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP RevA: New issue DD verified by:EC IPP rev:B as per dwg RevB
DD 10.03.03 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-15A		Purchased	No			110	Each	127.0000	8	40			
AN4-15A									**			PC	DAS 28 9-89

Location	Loc Qty	Loc Code
GA	26	
120449	26	
over003	100	
m135297	100	46
ST343	1	
m135127	1	

D2732-030		Manufactured	No			110	Each	44.0000	4				
D2732-030									**			PC	DAS 28 9-89

Location	Loc Qty	Loc Code
FG	40	
146999	40	
ST410	4	
147721	4	

cut(4) at 3.00" per kit													
D3595		Manufactured	No			110	sf	485.8880	0.0833	0.4165			
D3595									**			PC	DAS 28 9-89

Location	Loc Qty	Loc Code
MAT052	485.888	
94539	485.888	

(D3595-200-300) Cut(2) at 2.00" X 3.00" as per dwg
D3595 (per kit)

DAS
6
9-89

10 x B144898 AUG 17 2016

Picklist Print

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Page 2

Work Order ID: 149958

149958

Parent Item: DSI 9410-011

DSI 9410-011

Parent Item Name: Amends Installation of D350-591-311/-312 Steps

Start Date: 8/16/2016

Required Date: 8/30/2016

Start Qty: 5.00

Required Qty: 5.00

MS21042L4

Purchased

No

110

Each

1,591.000

40

MS21042L4

Nut

**

PC

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

51

m133363

51

GA

424

m133769

116

m135058

308

ST3003

26

m134955

26

ST303

1090

m135127

114

m135297

976

40

NAS1149D0463J

Purchased

No

110

Each

3,054.000

80

NAS1149D0463J

Washer

**

PC

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

240

M132035

15

M134508

32

M135056

193

ST260a

2600

M135390

1600

M135407

1000

ST263

214

M135056

214

80

DAS
6
9-89

AUG 17 2016

DART SERVICE INSTRUCTION

TO AMEND DRAWING D350-591 REV. F

REF. CANADIAN STC: SH92-6

FAA STC: SH967NE

TO IMPROVE THE FIT OF THE D350-591-311/-312 STEPS, IT IS ACCEPTABLE TO INSTALL THE DSI 9410-011 KIT. INSTALL THE D2732-030 CUSHION (AFT CROSSTUBE) AND D3595-200-300 CUSHION (FWD CROSSTUBE) AS SHOWN IN FIGURE 1 IN PLACE OF THE D2856-400-720 ABRASION STRIP CALLED OUT ON DRAWING D350-591 REV. F.

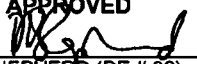
FOR CUSTOMERS WHO HAVE PREVIOUSLY INSTALLED D2856-400-720 ABRASION STRIPS REMOVE THE ABRASION STRIPS IN ACCORDANCE WITH ICA-D350-591. PRIOR TO INSTALLING THE DSI 9410-011 KIT.

DSI 9410-011 KITS WILL BE INCLUDED WITH D350-591-311/-312 STEPS AT CHANGE 002 AND SUBSEQUENT.

QTY -041	PART NUMBER	DESCRIPTION
X	DSI 9410-011	STEP MODIFICATION KIT
4	D2732-030	CUSHION
2	D3595-200-300	CUSHION
8	AN4-15A	BOLT
16	AN960JD416	WASHER
8	MS21042L4	NUT (OR MS21042-4)

AUG 15 2016

54 149958

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01
APPROVED 
BY: D. SHEPHERD (DE # 02)
DATE: 08.09.08
CERT. NO.: SH92-6
ISSUE NO.: 10

B	SHEET 1 DELETE REVISED P/L. (SEPERATE DSI KIT FROM MAIN KIT SEE NCR 08-082 FOR DETAILS)	AJS	08.09.08
A	NEW ISSUE	PH	08.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9410	SHEET 1 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	HA	STEP MODIFICATION KIT	NTS
DATE	08.09.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

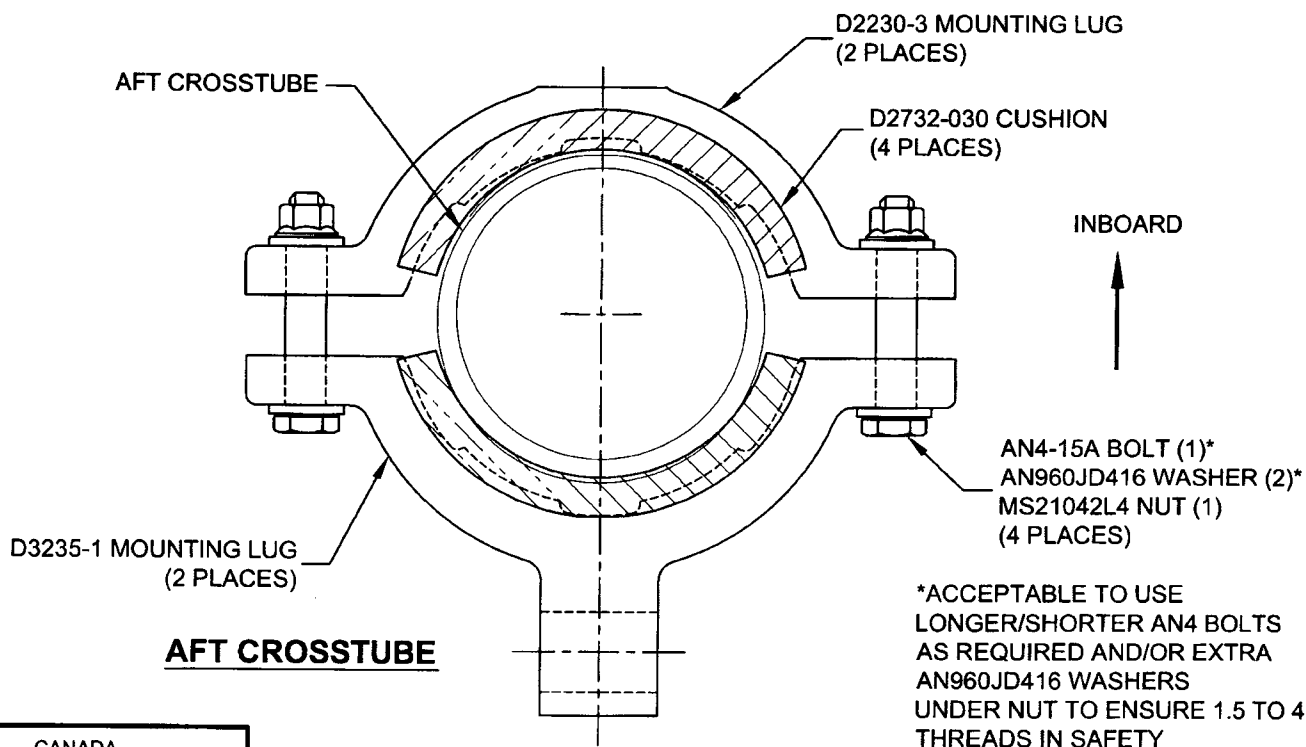
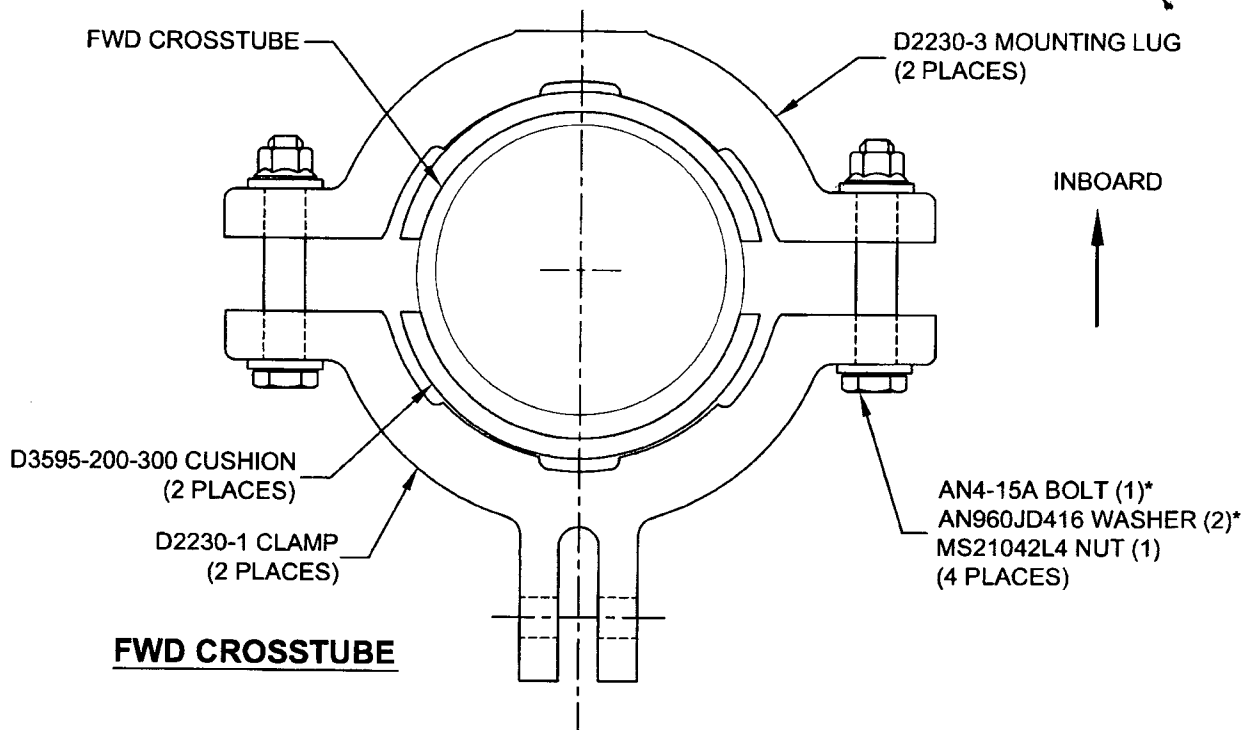


FIGURE 1 - CLAMP/CUSHION INSTALLATION

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
[Signature]
BY: D. SHEPHERD (DE # 02)

DATE: 08.09.08
CERT. NO.: SH92-6
ISSUE NO.: 10

DESIGN	ASS	DART AEROSPACE LTD	
DRAWN	ASS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9410	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STEP MODIFICATION KIT	NTS
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Work Order ID 149958

August 16, 2016 9:40:14 AM

149958

Page 1

Item ID: DSI 9410-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Amends Installation of D350-591-311/-312 Steps

Stop

NS2

Start Date: 8/16/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 8/30/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

SL

Date: AUG 15 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9410

B

DAS
21
9-89

100

Document Control

AUG 17 2016

DAS
21
9-89

AUG 17 2016

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP DSI 9410-011
CHG002

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.03

Quality Control

DART SERVICE INSTRUCTION

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REF. CANADIAN STC: SH92-6

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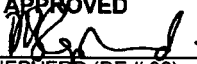
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CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

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MFG. APPR.	N/A	DSI 9410		SHEET 1 OF 2
APPROVED	AP	TITLE		SCALE
DE APPR.	SH	STEP MODIFICATION KIT		NTS
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